

Work Order ID 89413

89413

Page 1

August-24-12 1:57:58 PM

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 8/15/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/21/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/08/17 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>89413</u> Double check by: 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

D.A. 12/10/17

DAS 25 12-10-18

12-10-18

D.A. 12/10/17

(4)

(4)

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AWZ Date: 12/10/27QA Closed: CK Date: 11

Work Order: <u>89413</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No. <u>D3883-2</u>				Rework <input type="checkbox"/>		Skid-tube <input type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
NCR No. <u>12-1954</u>				Scrap <input checked="" type="checkbox"/>		Machining <input checked="" type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input checked="" type="checkbox"/>		Quality <input type="checkbox"/>		
				Use-as-is <input type="checkbox"/>		Thermoforming <input type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
				Work Order Update <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data <input checked="" type="checkbox"/>	<u>12-10-15</u>	<u>100</u>	<u>(2)</u>	<u>2 saddles dimension M .140-.165 are undersize and parts were run with +.015 offset and still came out to this EQUIPMENT Machine Error</u>		<u>12/10/17</u>	<u>HAAS 1 and HAAS 2 cannot read enough lines in advance to keep up with high feeds when profiling an angle resulting as overcuts and oval shapes. Setup has been moved to HAAS 3 and added a note to folios of the 4 models to run</u>	<u>12/10/17</u>	<u>DAS 16 2-89</u>	<u>DAS 16 2-89</u>				
Equip/Tooling <input type="checkbox"/>														
Operator <input type="checkbox"/>														
Material <input type="checkbox"/>														
Setup <input type="checkbox"/>														
Other <input type="checkbox"/>														
Process <input type="checkbox"/>														
Supplier <input type="checkbox"/>														
Training <input type="checkbox"/>														
Unapproved <input type="checkbox"/>														
Production Part/INSTR														
FAULT CATEGORY exclusively on Haas 3 or Haas 4														
Replace B														
Landing Gear			General											
<input type="checkbox"/>	Bending		<input type="checkbox"/>	Bend		<input type="checkbox"/>	Grain		<input type="checkbox"/>	Ovalized		<input type="checkbox"/>	Pressure/Forced	
<input type="checkbox"/>	Centre Not Concentric to O/S		<input type="checkbox"/>	BOM/Route		<input type="checkbox"/>	Hardware		<input type="checkbox"/>	Over/Under tolerance		<input type="checkbox"/>	Temperature/Cure	
<input type="checkbox"/>	Cracks		<input type="checkbox"/>	Broken/Damaged		<input type="checkbox"/>	Inspection Incomplete		<input type="checkbox"/>	Part Incorrect		<input type="checkbox"/>	Weld	
<input type="checkbox"/>	Crushed/Crimped		<input type="checkbox"/>	Burrs		<input type="checkbox"/>	Instructions Incomplete/Unclear		<input type="checkbox"/>	Part Lost/Missing		<input type="checkbox"/>	Wrong Stock Pulled	
<input type="checkbox"/>	Cuffs		<input type="checkbox"/>	Contamination		<input type="checkbox"/>	Maintenance		<input type="checkbox"/>	Part Moved		<input type="checkbox"/>		
<input type="checkbox"/>	Heat Treat		<input type="checkbox"/>	Countersink		<input type="checkbox"/>	Mislabeled		<input type="checkbox"/>	Positioned Wrong		<input checked="" type="checkbox"/>	Other	
<input type="checkbox"/>	Inspection Strip in Tube		<input type="checkbox"/>	Cut Too Short		<input type="checkbox"/>	Misread		<input type="checkbox"/>	Power Loss/Surge		<u>Not able to run at older machine</u>		
<input type="checkbox"/>	Ripples in Bend		<input type="checkbox"/>	Drill Holes		<input type="checkbox"/>	Offset		<input type="checkbox"/>					
<input type="checkbox"/>	Torque Waves in Extrusion		<input type="checkbox"/>	Drawing		<input type="checkbox"/>	Out of Calibration		<input type="checkbox"/>					
<input type="checkbox"/>	Turning Sequence		<input type="checkbox"/>	Finish		<input type="checkbox"/>	Out of Sequence		<input type="checkbox"/>					
<input type="checkbox"/>	Wave/Twist in Tube		<input type="checkbox"/>	Folio		<input type="checkbox"/>	Outside Dimensions		<input type="checkbox"/>					

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Page 2

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Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 8/15/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/21/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 2:45
 OVEN TEMPERATURE: 320 F
 FINISH TIME: 3:15

W122878

DAS
14
2-89 12/10/18

4 8

4 NB 12-10-18

4X 12/10/18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

August-24-12 1:57:58 PM

Page 1

Work Order ID: 89413

Parent Item: D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 8/15/12

Required Date: 9/21/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 Saddle Billet		Manufactured	No				Each	1.0000		4			

Location

Loc Qty

Loc Code

MAT047

1

85568

1

89823

4 + 2 = 6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

DART AEROSPACE LTD		Work Order:	89413
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1	

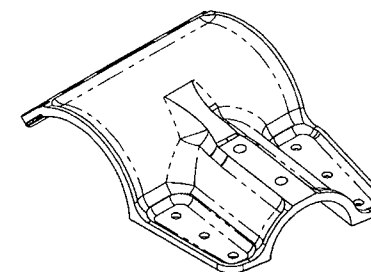
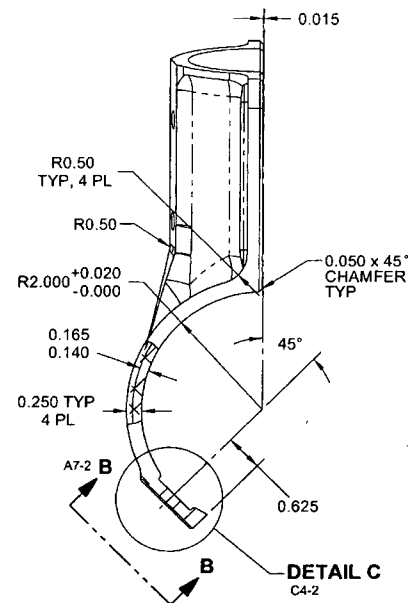
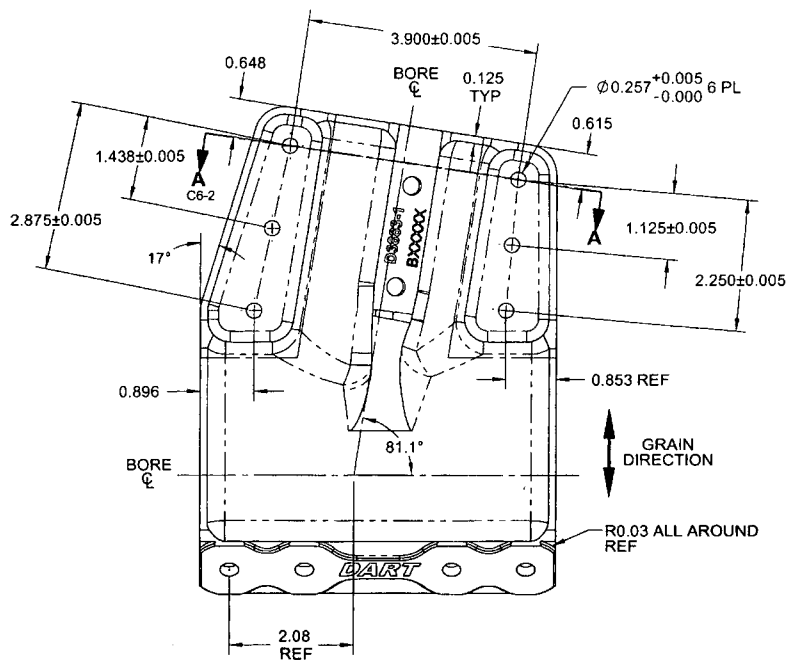
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.647	0.647	0.646	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.614	0.614	0.613	0.613		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.002	2.002	2.004	2.002		
J	0.140	0.165		0.156	0.148	0.147	0.150		
K	0.240	0.260		0.258	0.247	0.246	0.249		
L	0.115	0.135		0.125	0.122	0.124	0.124		
M	0.140	0.165		0.155	0.148	0.148	0.150		
N	0.720	0.780		0.770	0.770	0.770	0.770		
O	0.240	0.260		0.251	0.249	0.249	0.249		
P	0.110	0.140		0.140	0.140	0.140	0.140		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.870	2.870	2.870	2.870		
S	0.316	0.321		0.317	0.317	0.317	0.317		
T	0.990	1.010		0.999	0.998	0.998	0.998		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.001	6.001	6.001	6.001		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.504	0.503	0.503		
Y	1.220	1.280		1.253	1.253	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.316	0.316	0.316	0.316		
AB	0.020	0.040		0.030	0.030	0.030	0.030		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.218	0.215	0.218	0.218		
AE	1.265	1.285		1.267	1.268	1.269	1.267		
AF									
Accept/Reject									

Measured by:	SL
Date:	12-10-18

Audited by:	DAS
Date:	12/10/18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	ILM
B	09.11.25	Dimension AE added	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 89413 ML5
12/08/27

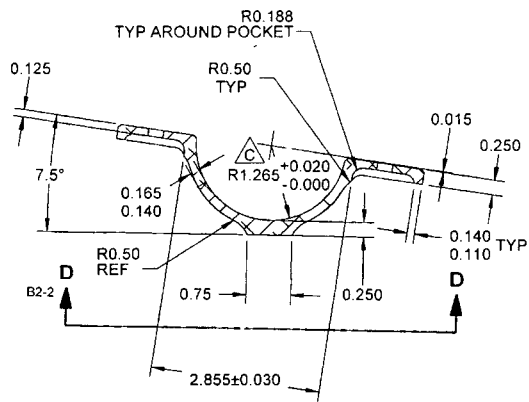
RELEASED
2009-11-19
MJP

D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

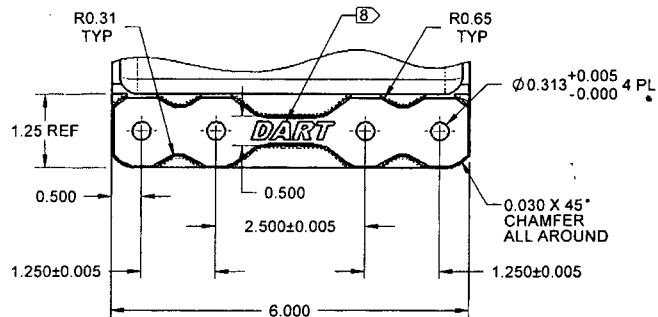
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

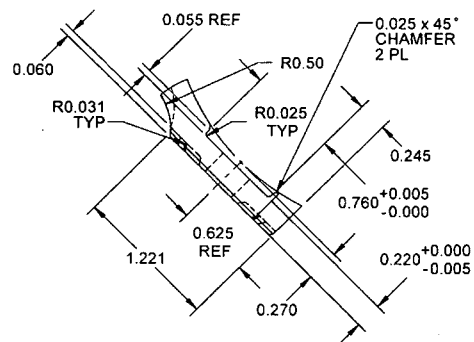
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3883	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
DATE	09.11.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



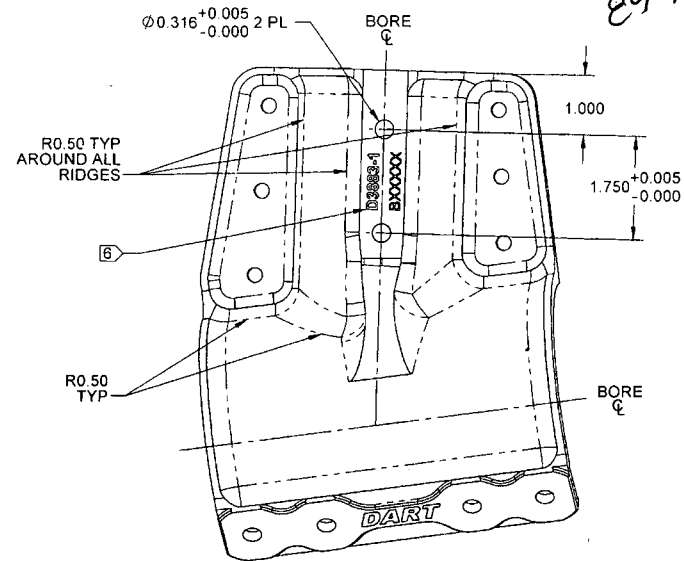
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

RELEASED
2009-11-19
MP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3883	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
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